

Date: Wednesday, 10/11/2006 12:49:23 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 EXTRUSION BENDING	
Job Number	: 28932				
Estimate Number	: 10311				
P.O. Number	: N/A		Part Number	: D2620	
This Issue	: 10/11/2006 S.O. No. : N/A		Drawing Number	: D2620 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A Type : LANDING GEAR		Drawing Revision	: B	
Previous Run	: 28457		Material	: N/A	
Written By			Due Date	: 10/30/2006 Qty: 30 Um: Each	
Checked & Approved By					
Comment	: Est. D 02.08.20 Change Dwg to rev.B; Updated Location RF				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26001160	Extrusion Round 3" 206	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion Round 3" 206			
	Pick;		
Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	<i>B24508 DP 6-11-2</i>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008			
2- Cut Fwd end of tube as per Dwg D2620 <i>DM 06-11-2</i>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP <i>QE 06-11-06</i>			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <i>LG</i> <i>QE 06-11-06</i>			
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
<b>Comment:</b> FINAL INSPECTION/W/O RELEASE <i>SP 06/11/06</i>			
Job Completion			<i>U 06-11-06</i>

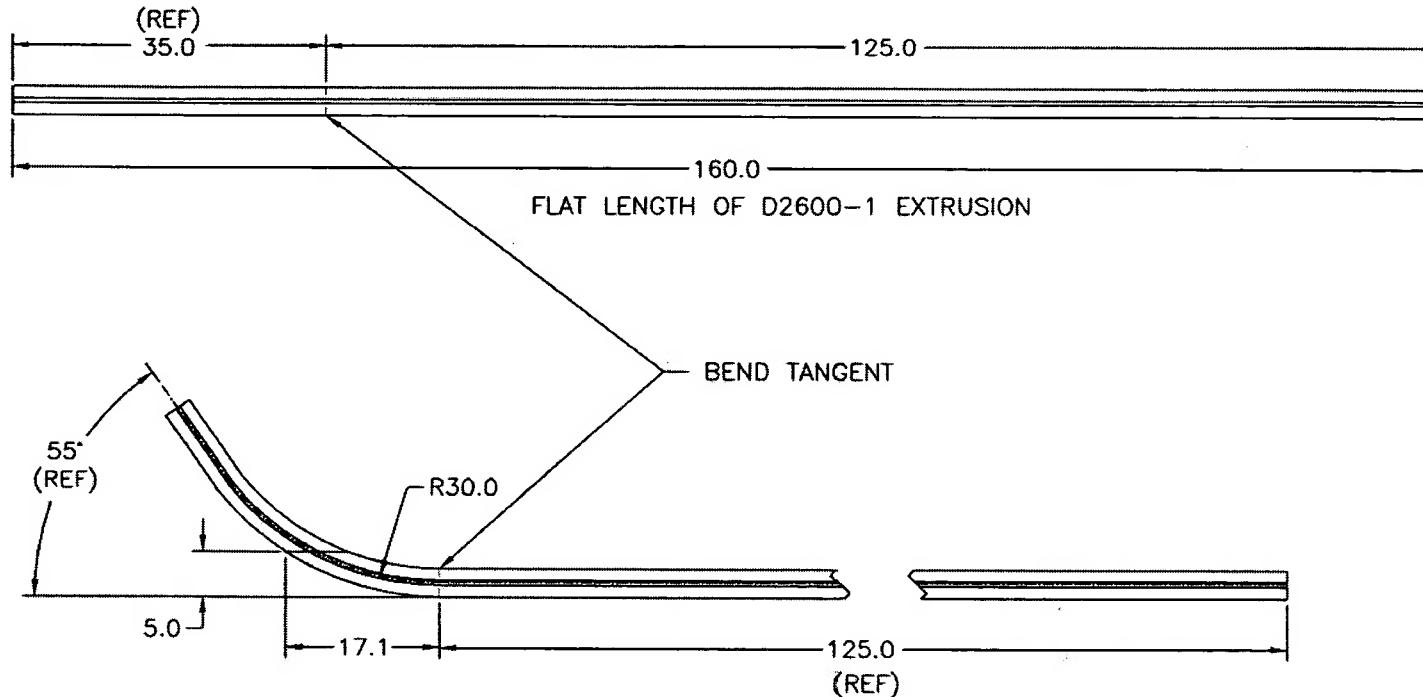
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/11/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING  
206 SKIDTUBE BENDING



## DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
  2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.  
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.  
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
  3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND.  
TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
  4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND.  
TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**RELEASE**

49-09-15	DS
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		DRAWN BY <u>R F</u>		DART AEROSPACE USA, INC.	
				FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <u>OK</u>	APPROVED <u>KE</u>	DRAWING NO.		REV. B	
		D2620		SHEET 1 OF 1	
DATE 99.09.10	TITLE 206 SKIDTUBE BENDING CONTROL			SCALE	
		1:20			
A	97.11.07	NEW ISSUE			
B	97.09.10	UPDATE FOR IN-HOUSE BENDING			

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